

ABSTRACT OF THE DISCLOSURE

An acceleration and deceleration control in which, for a relation between speed and acceleration, the low speed part need not be symmetrical with the high speed part, is performed such that an actual acceleration curve may lie along a restricted acceleration curve as much as possible. A curve representing actual acceleration-speed, corresponding to time-speed transition to be planned, approaches a restricted acceleration curve. When supplying a movement command which has been subjected to acceleration and deceleration processing to a servo control section, acceleration in the acceleration and deceleration processing is determined such that a speed-acceleration curve of the movement command which has been subjected to acceleration and deceleration processing may lie along predetermined speed-acceleration curve. The speed-acceleration curve is set for each axis and dependent on acceleration or deceleration, using parameters.